

Date: Wednesday, 07/01/2009 8:42:57 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 SKIDTUBE ASSEMBLY LH
<b>Job Number</b> : 44419	
<b>Estimate Number</b> : 10262	
<b>P.O. Number</b> :	<b>Part Number</b> : D350636011
<b>This Issue</b> : 07/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2750 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 44418	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/01/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.07</u>	
<b>Comment</b> :	
Est Rev:I 02.09.25 Rearranged procedure steps KJ	
Est Rev:J 06-03-23 As per Rev D JLM	
Est Rev:K 06-07.13 As per dsi9343 EC	
Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM	
Verified By:EC	
Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC	
Est Rev:N 08-09-23 revF as per dwg DD verified by:ec	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JUD 09/01/22*

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

*8 09/01/22*

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

Batch

*B-43495*

*AvM 9-1-8*

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: *242713 BE 09/01/08*

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details):Drill using drill Jig DT8150 & DT8863. *AvM 9-1-8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.
- 4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"
- 5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting
- 6-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)
- 7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".
- 8-Open up holes of Detail A to 0.297" (total of 2 holes per side)
- 9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m/09560 BE 09/01/08*
- 10-Grind welds flush as per Dwg D2750 *Pm' 09-01-12*
- 12- Scribe batch# inside per dwg D2750 *- AWM 9-1-8*

*- AWM  
9-1-8*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 09/01/12 (40)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/01/12 (10)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Pm' 09-01-12*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BE 09-01-12*

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B44520

PM 09-01-12

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B43013

BE 09/01/13

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B42979

BE 09/01/13

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B42777

(2x)

B43110

(6x)

BE 09/01/13

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on  
sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

PM  
09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description:

7-Bond web D2739 in place as per QSI 015

AdR

Sikaflex-291

batch: m109583

exp. date: 09-07-11

pmc 09-01-12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 8)

AdR

Aluminum Rod

batch:

m109560

BE 09/01/13

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11-Deburr holes

- AWM  
9-1-13

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/14 (X)

15.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/14 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FD 09/01/21 (1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

10:30 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:00 AM

JP 09-01-21 (X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

AM 09-01-21 (1)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M109817

A.M 09.01.21 (1)

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Install inserts as per Dwg D2750

A.M 09.01.21 (1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: B43754

A.M 09.01.21 (1)

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B43890

A.M 09.01.21 (1)

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B43459

A.M 09.01.21 (1)

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B43460

A.M 09.01.21 (1)

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B43147

A.M 09.01.21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: 342486

*A.M. 09.01.210*

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B43405

*A.M. 09.01.210*

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B43454

*A.M. 09.01.210*

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: B43346

*A.M. 09.01.210*

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B41141

*A.M. 09.01.210*

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, LH

Batch: B41153

*A.M. 09.01.210*

32.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

NAS1611-010 batch: 011046

(or MS28775-010) batch: \_\_\_\_\_

*A.M. 09.01.210*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1611013	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
O-RING  
batch: M106513

A.M 09.01.21 ①

34.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: B 44343

A.M 09.01.21 ①

35.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: B 44344

A.M 09.01.21 ①

36.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)  
Bolt  
Batch: M110002

A.M 09.01.21 ①

37.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: M 10880

A.M 09.01.21 ①

38.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
BOLT  
Batch: M110105

A.M 09.01.21 ①

39.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
BOLT  
Batch: M 110105

A.M 09.01.21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M110139

a.m 09.01.210

41.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M110139

a.m 09.01.210

42.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M110002

a.m 09.01.210

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M109740

a.m 09.01.210

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M110450

a.m 09.01.210

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M109539

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M109883

EXP DATE: 09.11

a.m 09.01.210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M 10123

5-Coat all exposed fasteners with "LPS Procyon" batch: MD4251

Q.M 09 01.21 0

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 01/01/21 (10)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 42222

BN

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

BN

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110139

BN

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

BN 9/01/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44419

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M/10372

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: 44886

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch: 42350

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 09.01.23

D350-636-011

B44419

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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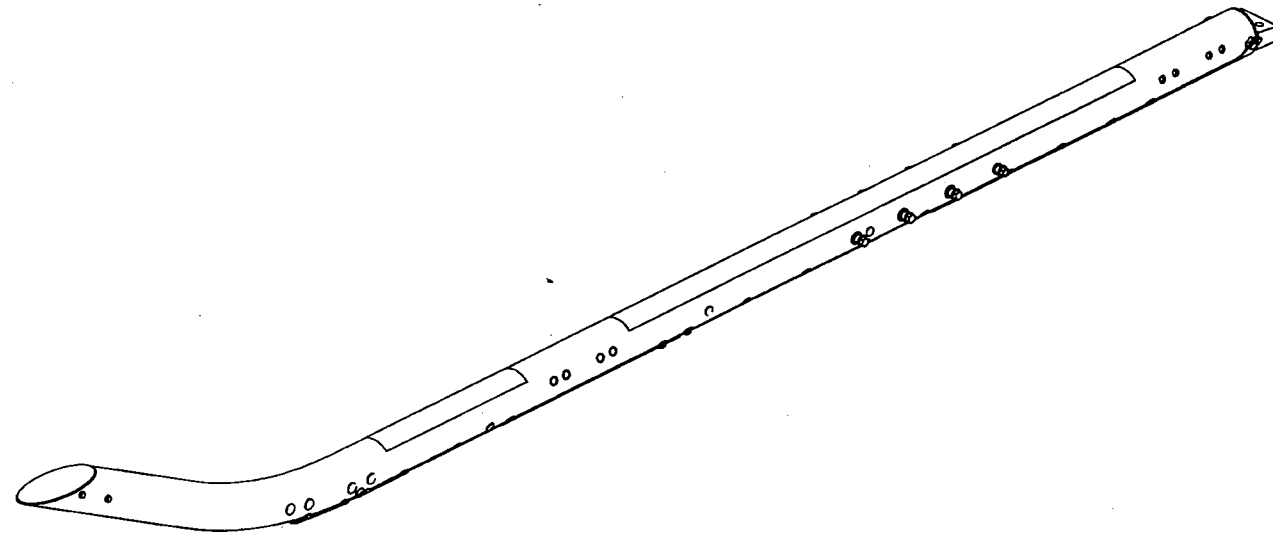
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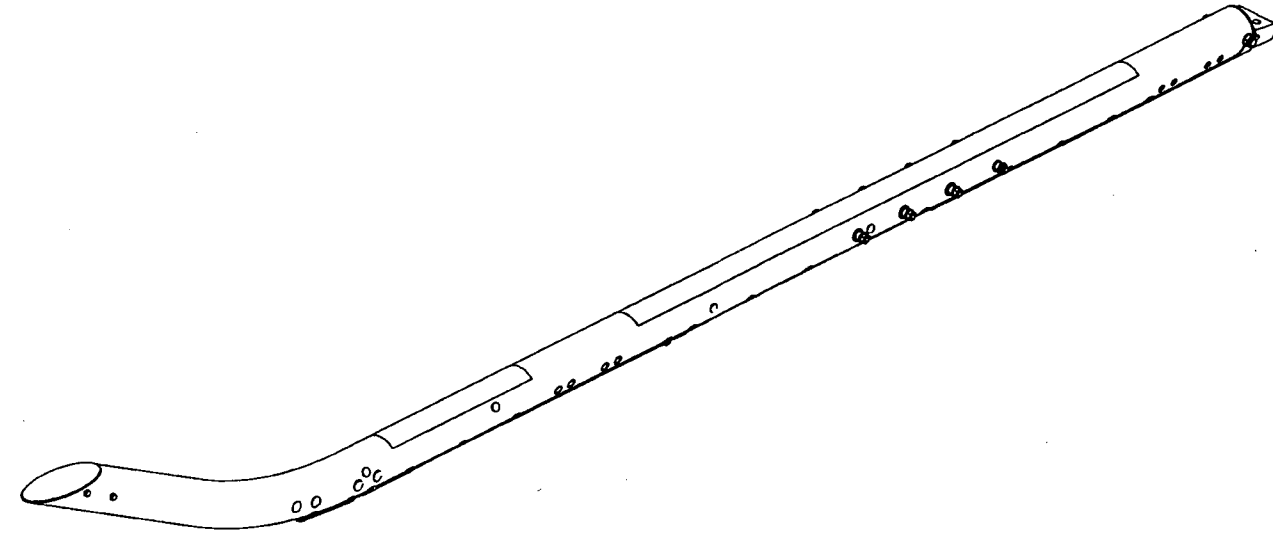
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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

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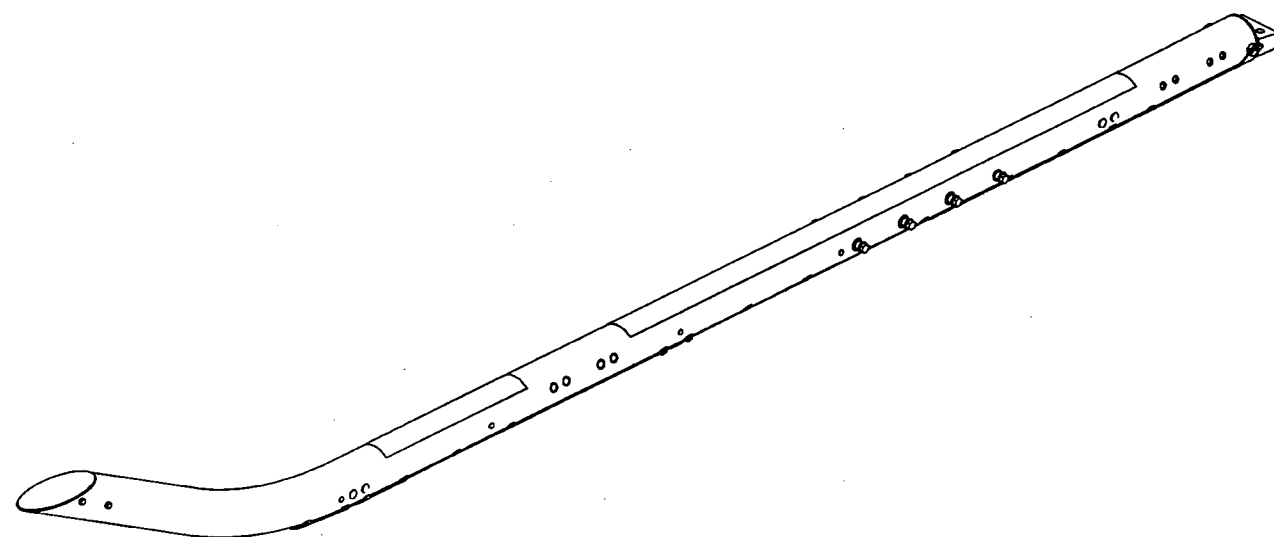
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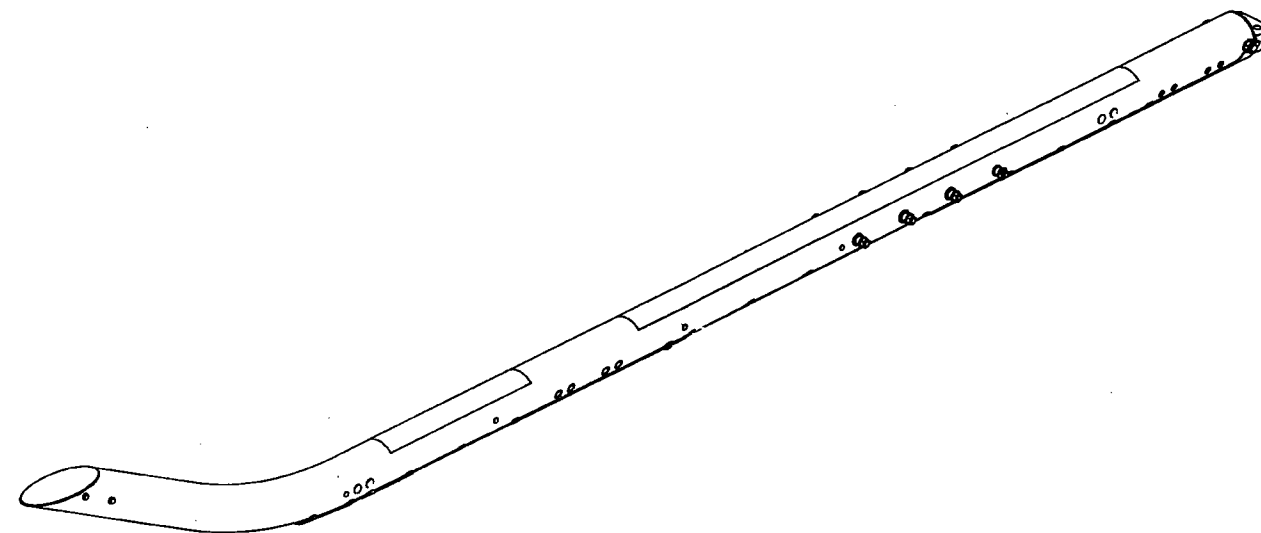
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



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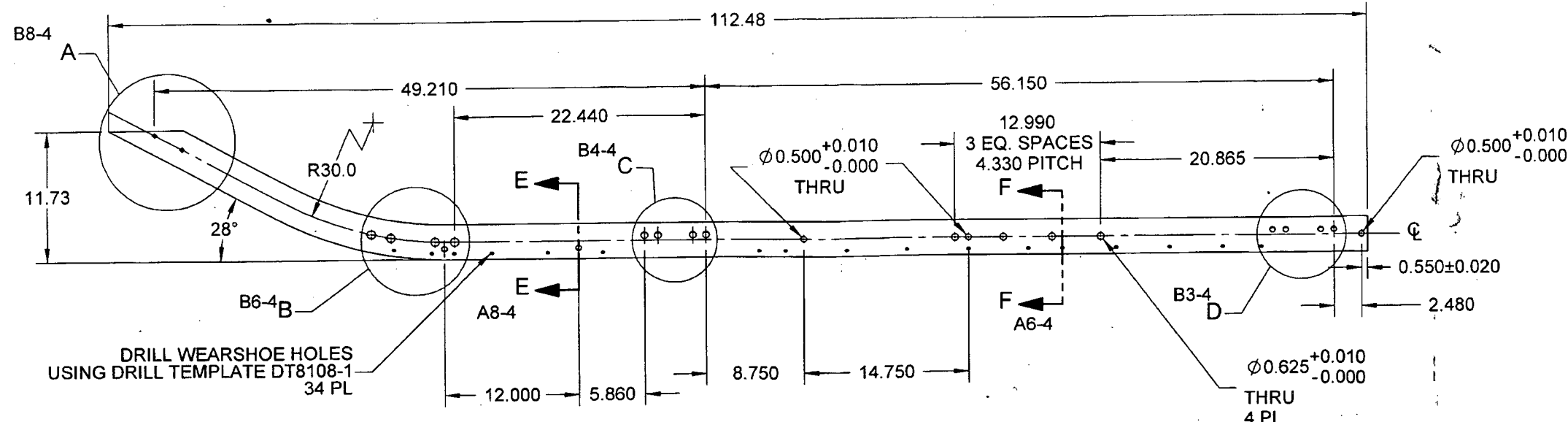
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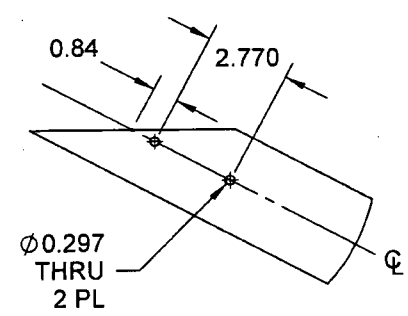
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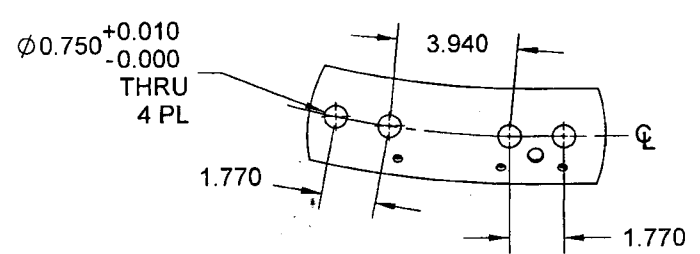




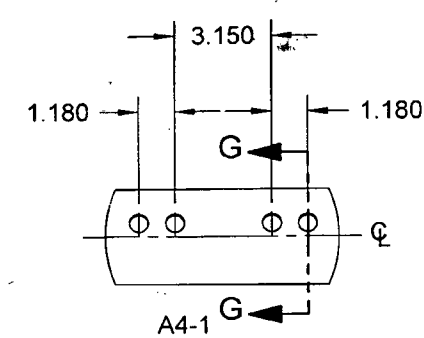
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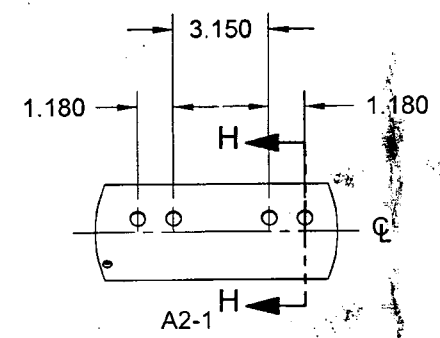
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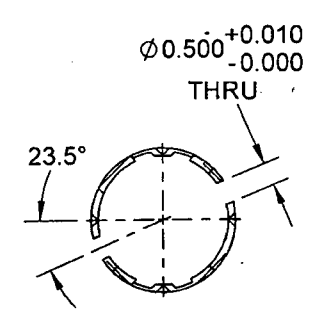
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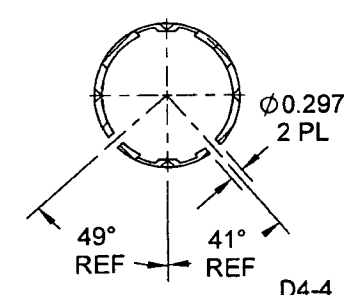
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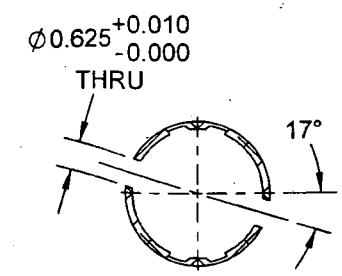
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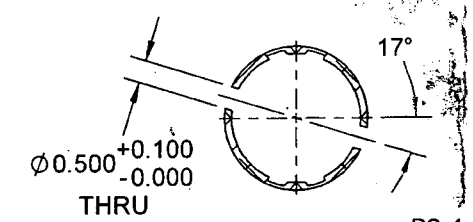
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**SECTION F-F**  
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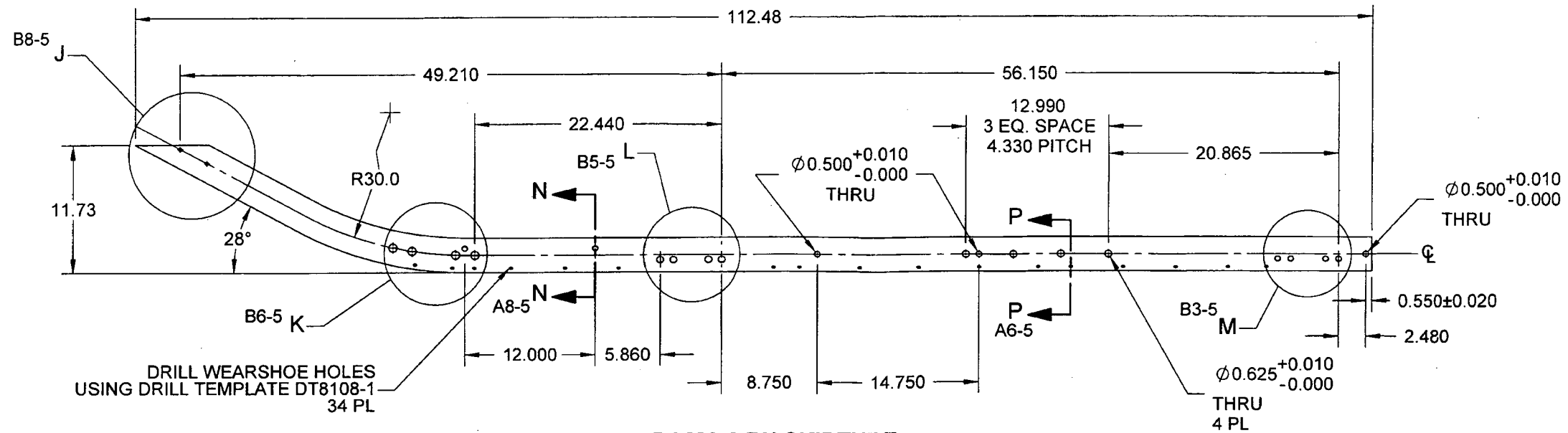
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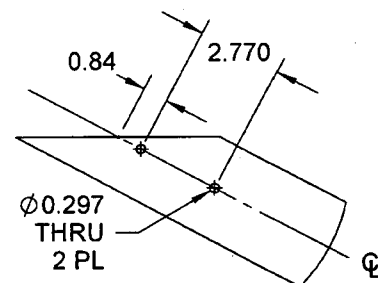
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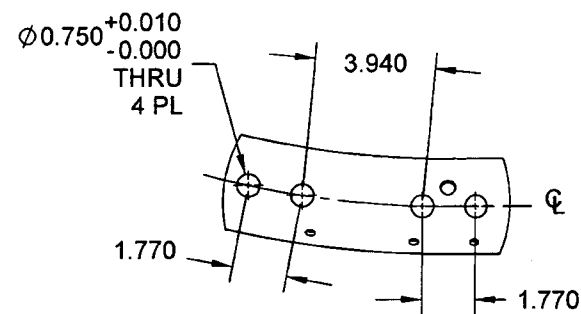
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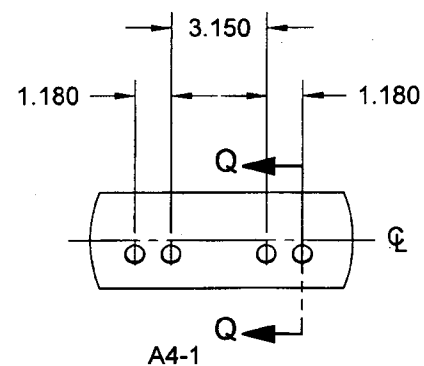
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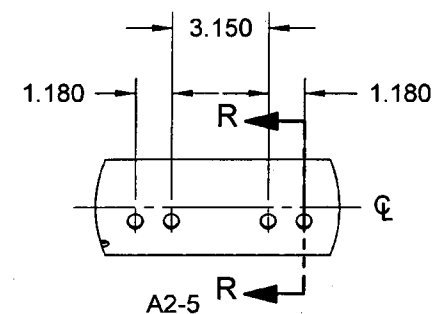
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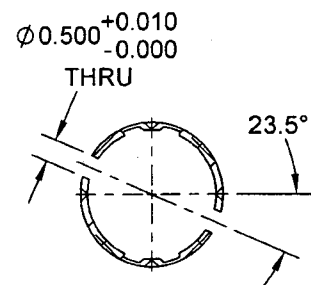
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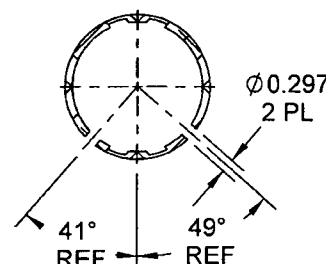
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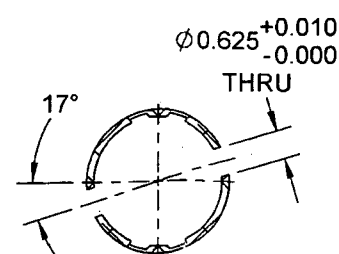
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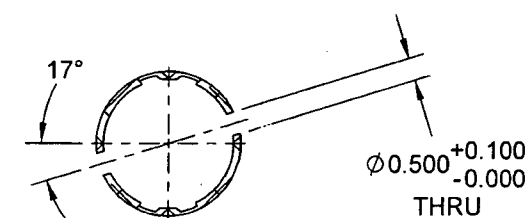
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**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
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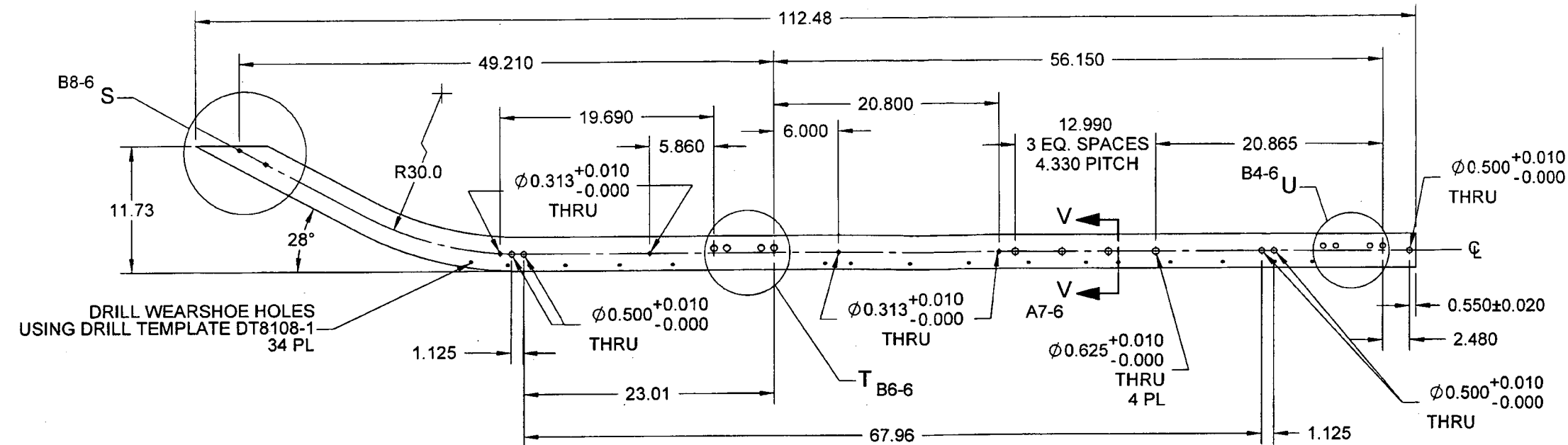
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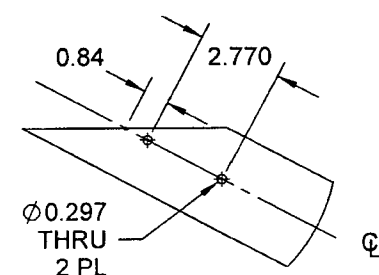
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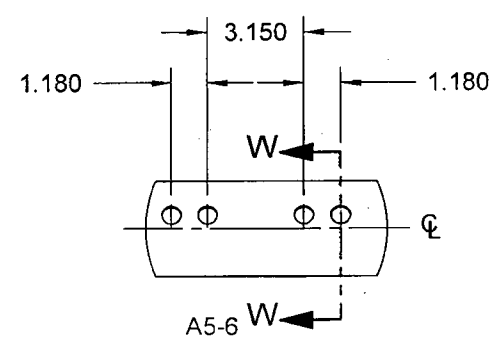
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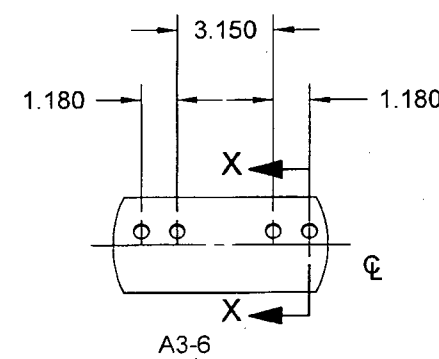
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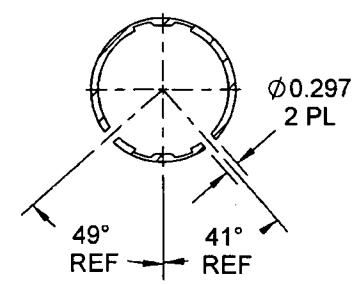
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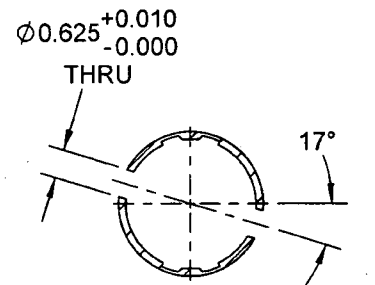
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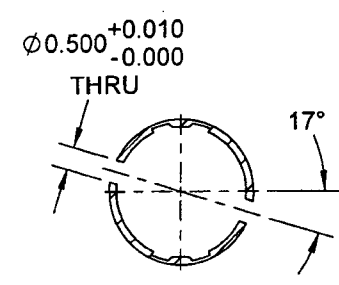
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

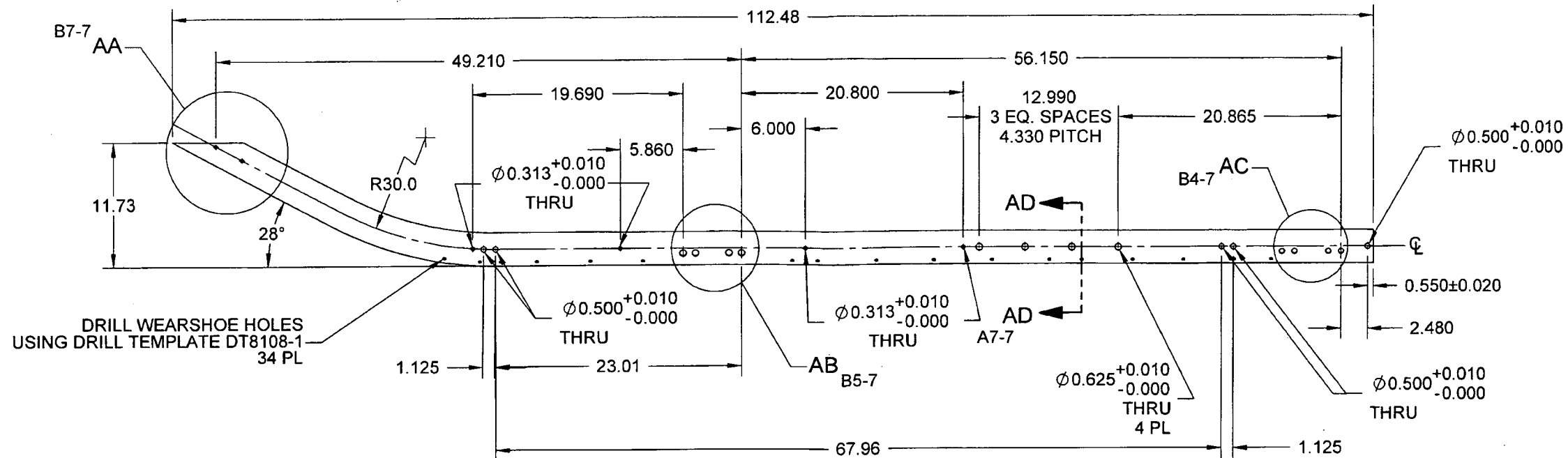


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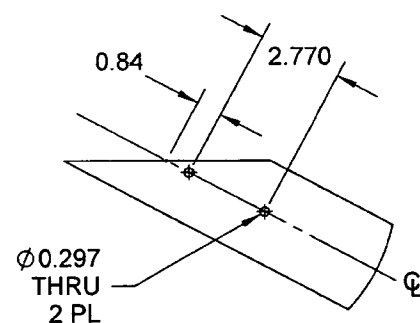
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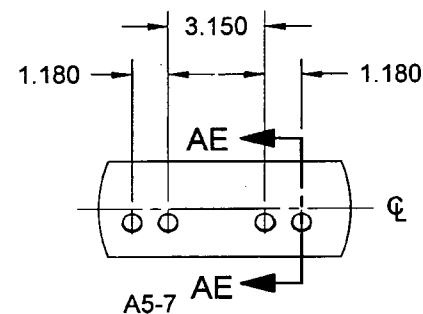
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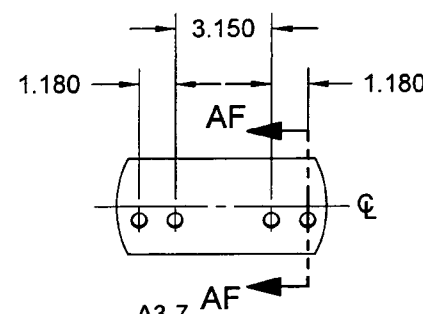
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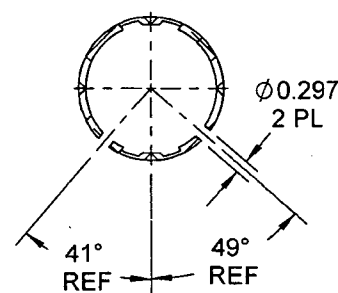
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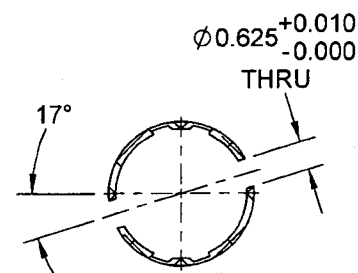
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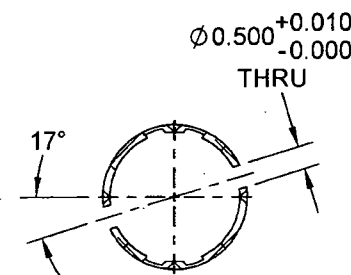
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**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL

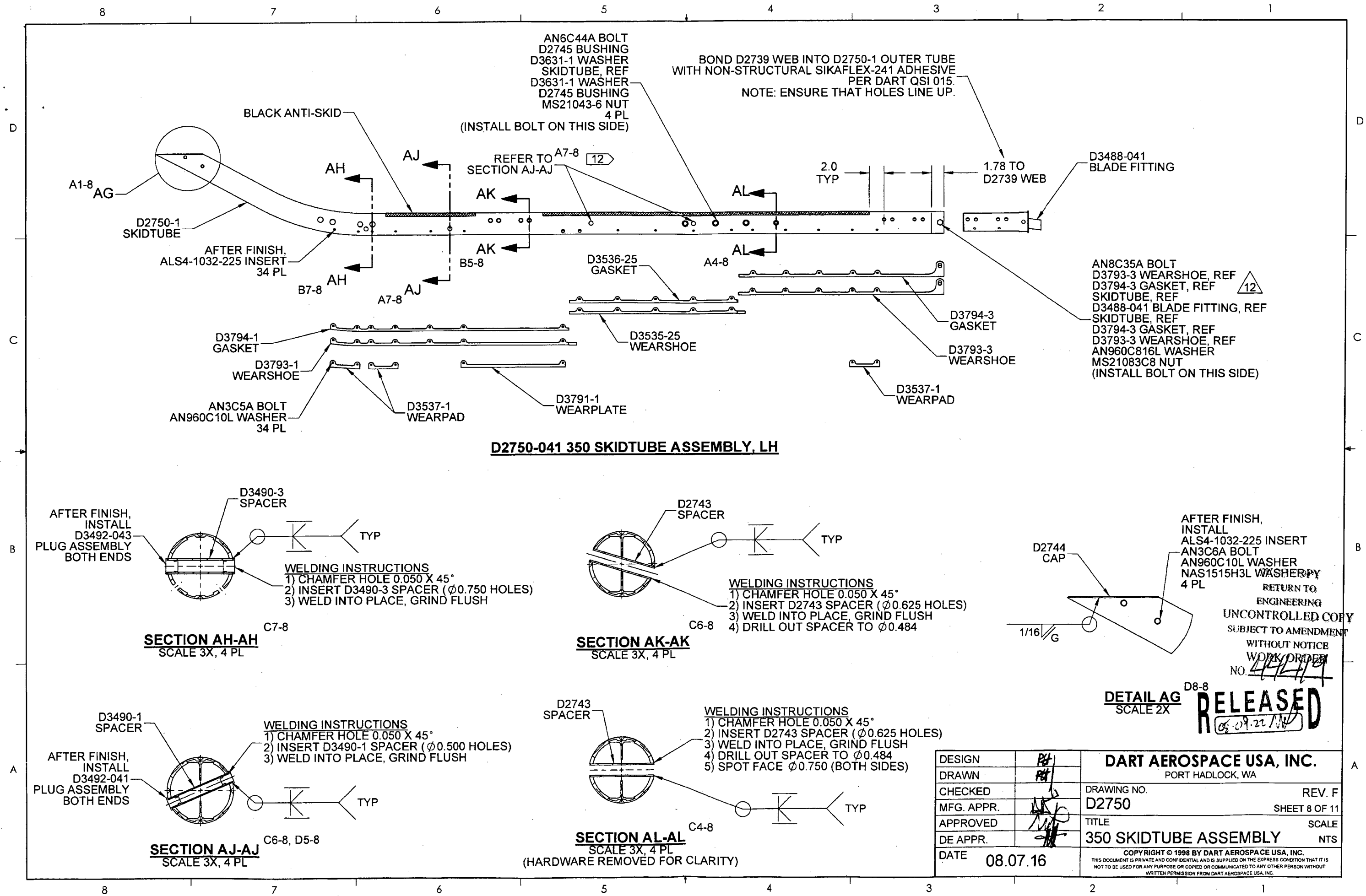


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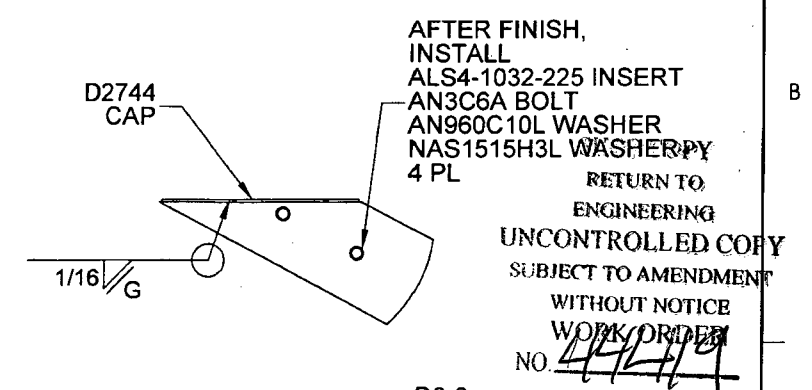
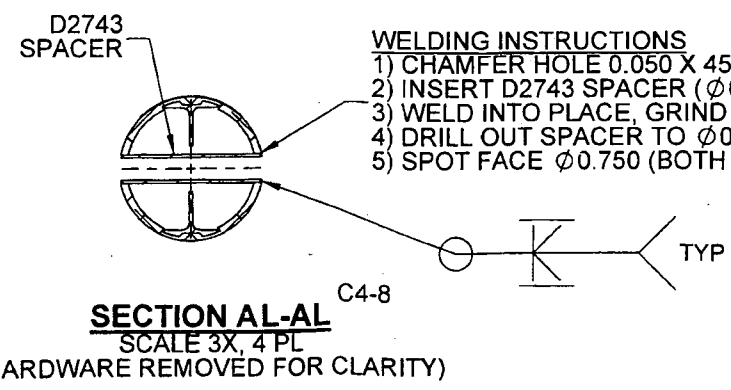
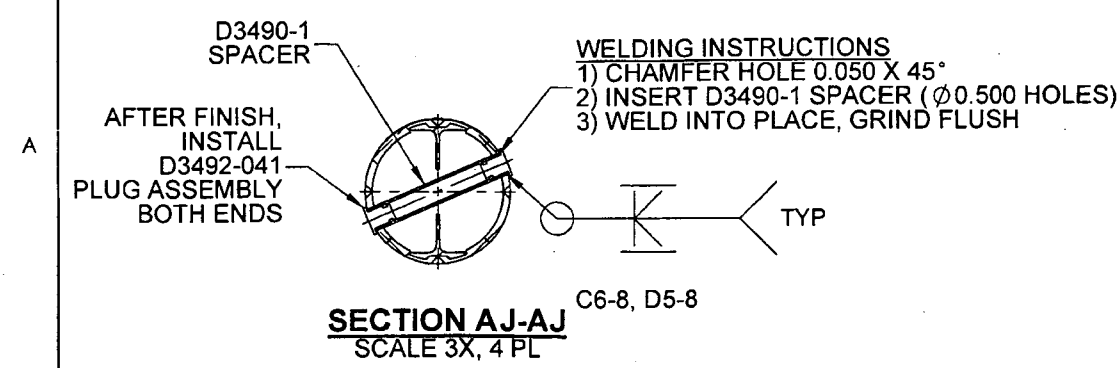
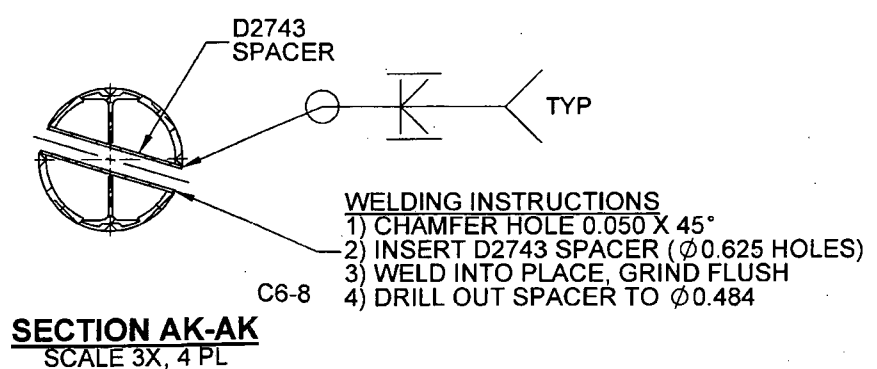
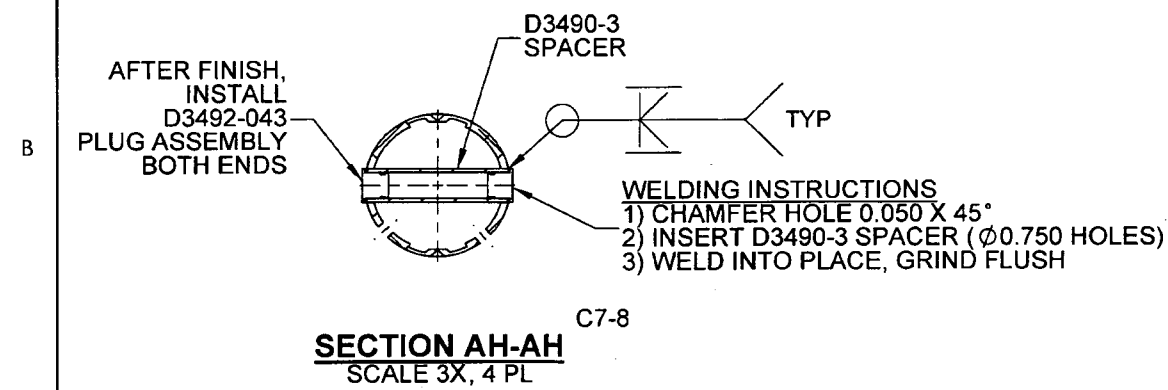
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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



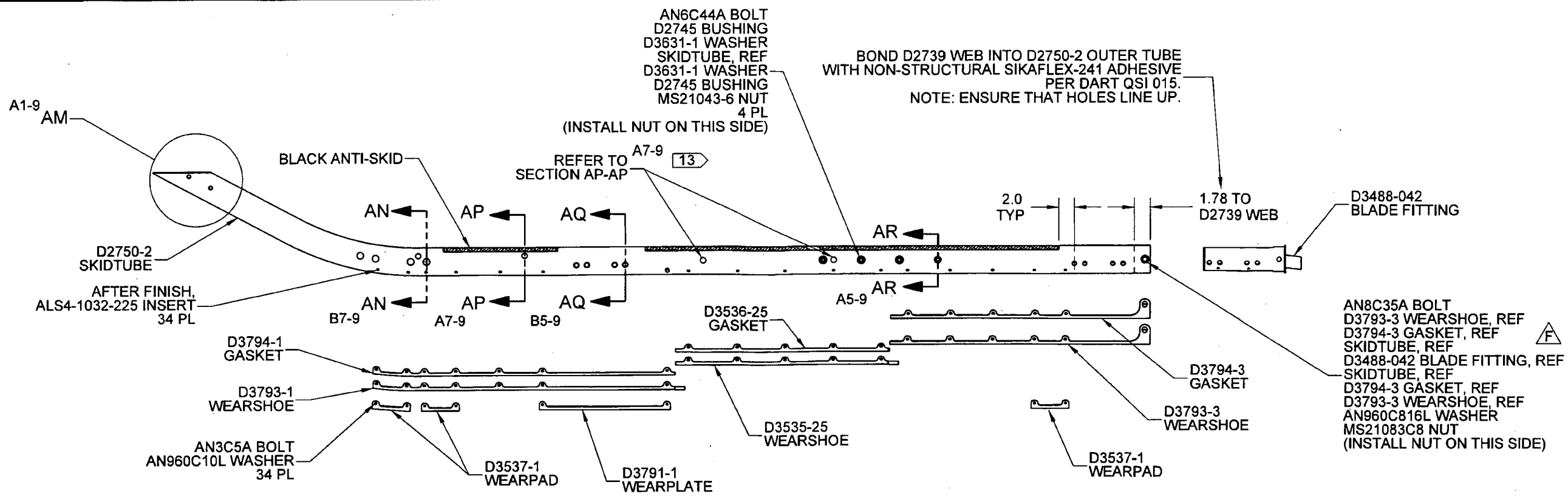
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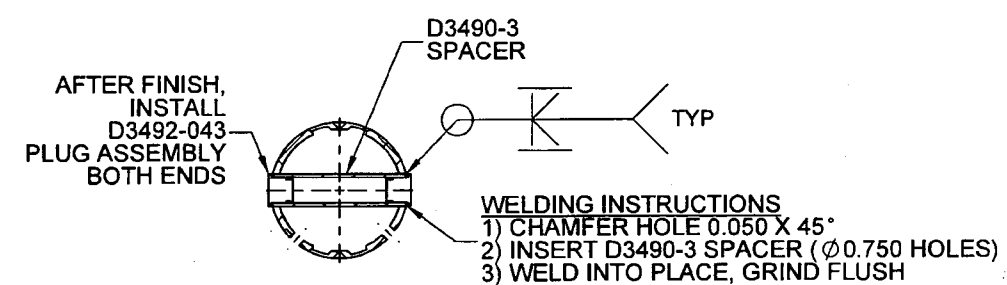
8 7 6 5 4 3 2 1

D  
C  
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A

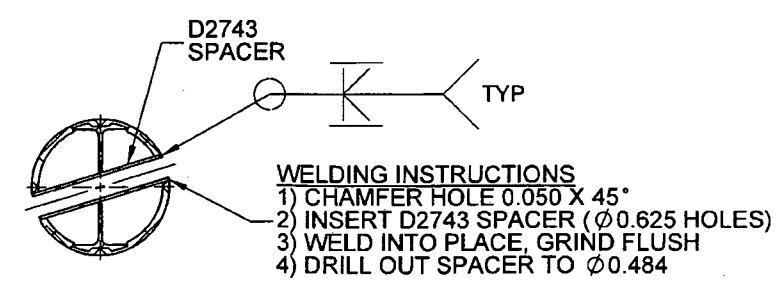
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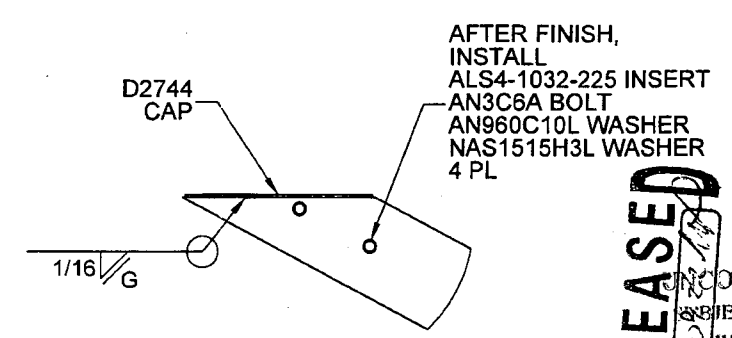
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



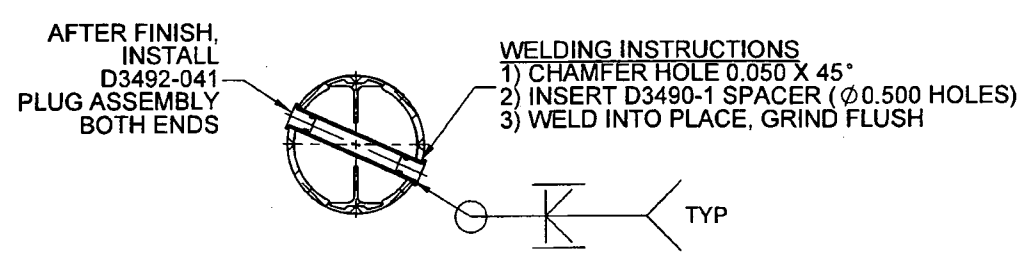
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SCALE 3X, 4 PL



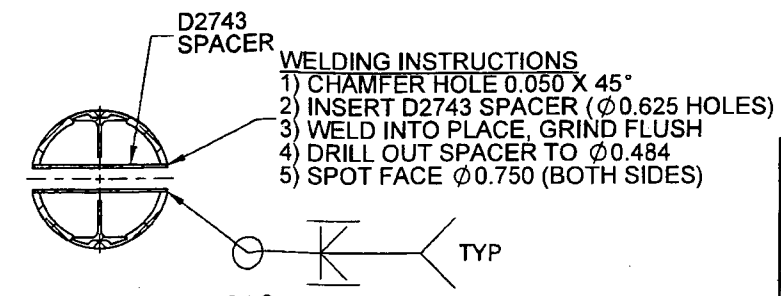
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**DETAIL AM**  
SCALE 2X



**SECTION AP-AP**  
SCALE 3X, 4 PL

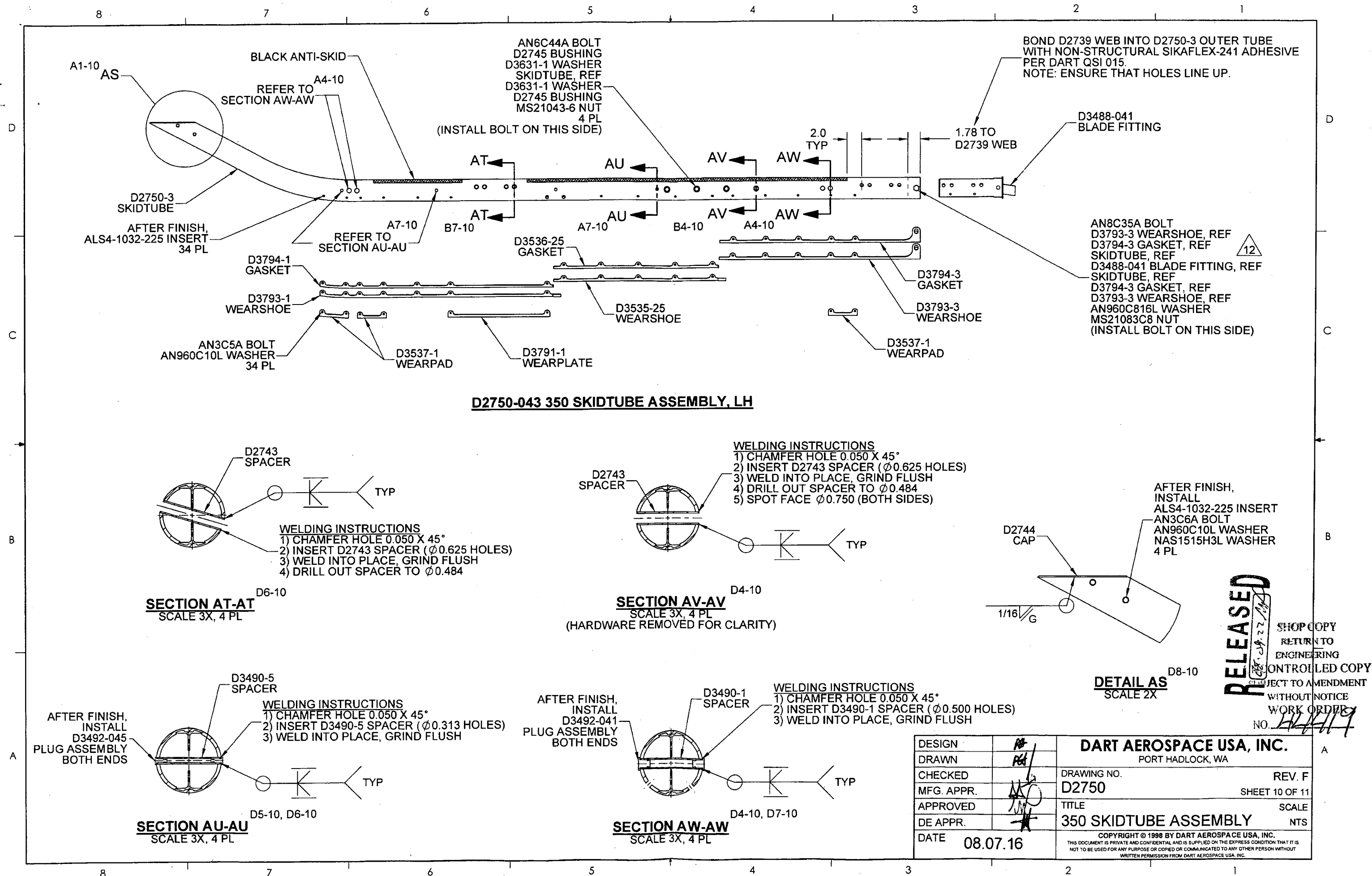


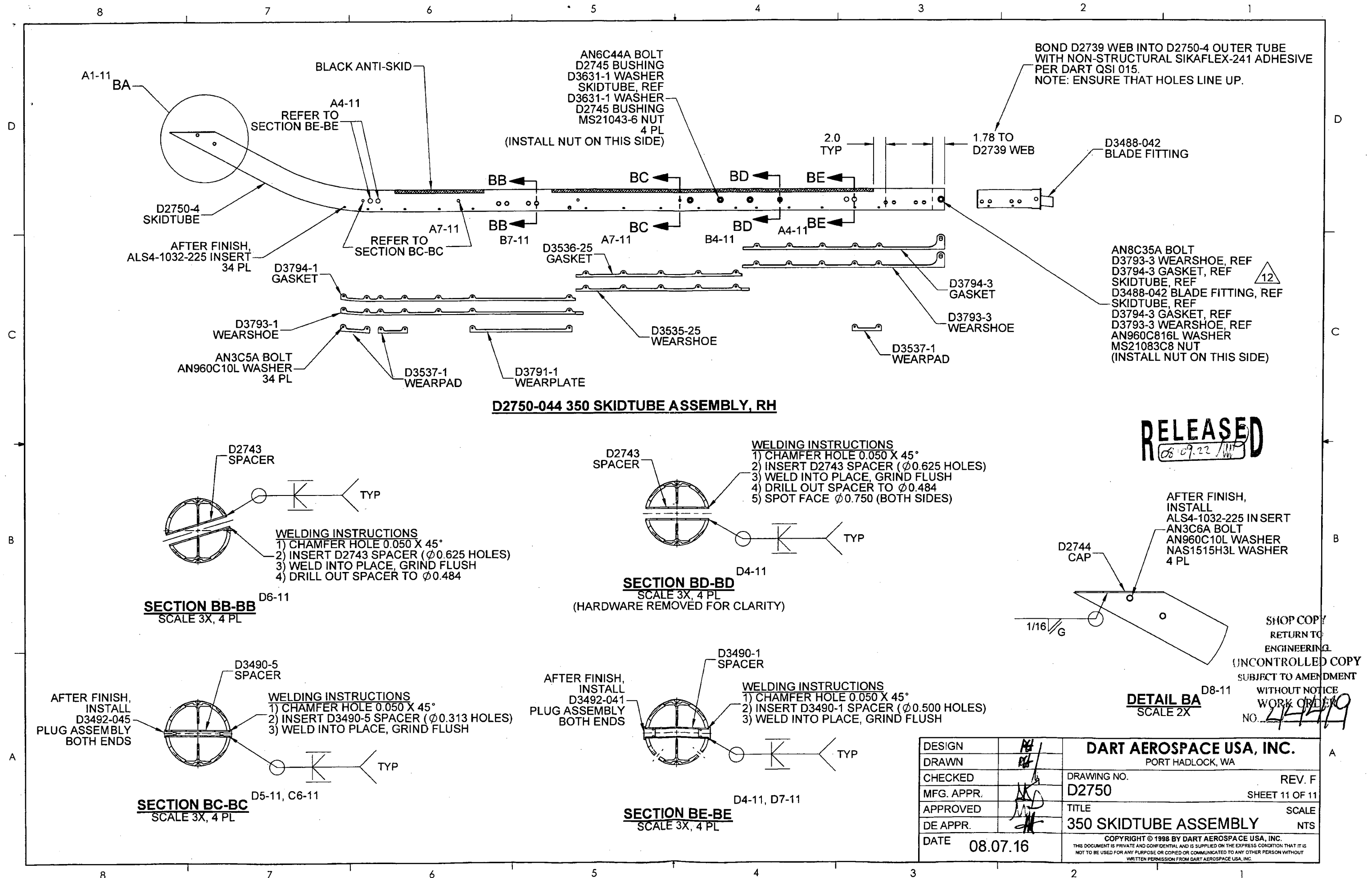
**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1









NO. 183

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: B243428  
Part number: A350 636 013  
Description: 350 Skid tube  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Alum  
Current: AC[ ☒ ] DC[ ☐ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

**UNACCEPTABLE**

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier David Lavel Date of Test Coupon 08/11/20  
Welder Barclay Elliot Date of Test Coupon 08/11/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld